

**Abstract**

The invention relates to a method for producing a coupling on a pipe (1), preferably consisting of copper or steel or Cu-, Ni-, Fe-alloys, by a preferably graduated or one-stage expansion of the pipe end to create a much larger difference in diameter, an expansion tool (2) being introduced axially into the end of the pipe. The invention is characterized in that when and/or once the expansion tool (2) has been introduced into the pipe end the region of the pipe end that is to be or has been expanded is completely or partially compressed by a force acting axially on said pipe end, whereby the external diameter of the pipe end that is to be processed is delimited by one or more shaping jaws (3) that completely or partially surround the pipe end. The invention also relates to a device for producing a coupling on a pipe end according to said method.